

Work Order ID 96781

Monday, February 04, 2013 8:54:45 AM

96781

Page 1

Item ID: D2986-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rubber Spacer

Stop

NS2

Start Date: 2/4/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/5/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:	Process Plan:	JMF	Date: 13-2-04	Tooling:		Date:		Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):		Date:		Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo	0.00	2	0	JM 13-2-4
D2986	Rev B	1-Cut as per Dwg D2986 Dwg Rev: B Prog Rev: B 2-Deburr if necessary	0.00	1	0	JM 13-2-5
100		FLOW WATER JET	0.00			
100		Waterjet	0.00			
FLOW CNC Waterjet		Memo	0.00			
		QC2- Inspect parts off machine FAI/FAIB	0.00			
110		Memo	0.00			
110		***template DT3187-1T1***	0.00			
120		QC8- Inspect parts - second check	0.00			
120		Memo	0.00	5		
QC		DAS 15 8-8 13-2-4				
Quality Control						

~~Scrap +~~ - Recut x
B# ~~14935~~ ~~x~~

metall hard due to measures in some locations.

Scrap + deshoy.

Scrap x 1

Dart Aerospace Ltd

W/O: 96781	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2986-1 PAR #: Fault Category: water jet NCR: Yes No DQA: ✓ Date: 13/02/08

Resolution: Disposition: Scrap QA: N/C Closed: ✓ Date: 13/02/08

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
13-2-S	116	material as hard burn marks in some locations QTY ①	DAS 16 2-08 as per B215	Scrap and Destroy Next 4 B# 114037	Am 13-2-S	DAS 15 2-08 as per B215	DAS 16 2-08 as per B215	DAS 16 2-08 as per B215
		R-6 part moves on w/2 tools operator error			\$15.59			

NOTE: Date & initial all entries

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Page 2

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N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rubber Spacer

Stop

NS2

Start Date: 2/4/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/5/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: CA

0.00

130

Packaging

Packaging

Memo

0.00

MF

13-2-06

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

13/2/6 48

MF

13-2-06

Picklist Print

Monday, February 04, 2013 8:54:44 AM

Page 1

Work Order ID: 96781

Parent Item: D2986-1

Parent Item Name: Rubber Spacer

Start Date: 2/4/2013

Required Date: 2/5/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B 09-01-20 rev.B as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125 4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"		Purchased	No			100	sf	236.1800	5.466	1250.7368 12		Jm 13-2-4	

Location	Loc Qty	Loc Code
MAT052	236.18	
114937	236.18	114937

DART AEROSPACE LTD	Work Order:	96781
Description: Rubber Spacer	Part Number:	D2986-1
Inspection Dwg: D2986 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

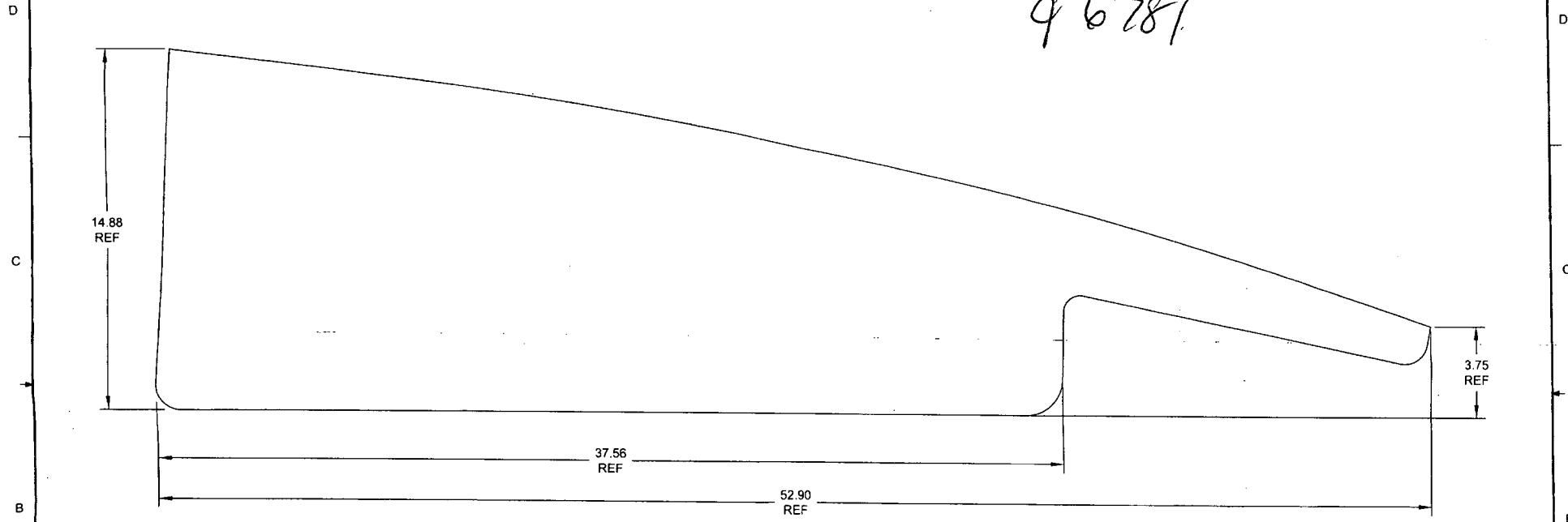
20

15

Measured by:	Jm	Audited by:	15 8-89	Prototype Approval:	N/A
Date:	13-2-4	Date:	13-2-4	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	M

8 7 6 5 4 3 2 1



D2986-1 RUBBER SPACER

RELEASED
09-01-08 MM

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET (ROLL), 0.125 THICK, PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1 (REF. DART SPEC. M-4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.3 lbs
- 8) TOOLING: CUT PER TEMPLATE DT3187-1T1

8 7 6 5 4 3 2 1

B	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED PART DWG DETAIL; REVISED NOTE 1; REMOVED SUPPLIER AND SPEC DWG NOTES. REASON: ECN#08-589.	MB	08.12.18
A	NEW ISSUE	DS	00.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>MM</i>	DART AEROSPACE LTD	
DRAWN	<i>MM</i>	HAWKSBURY, ONTARIO, CANADA	
CHECKED	<i>MM</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MM</i>	D2986	SHEET 1 OF 1
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	RUBBER SPACER	NTS
DATE	08.12.18	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	